Work Ord Monday, July 0				*12	1953*							Page	e 1
Item ID: Revision ID: Item Name:	D3414-041			Accept	*N900	040	110	N *	Setup	Start Stop		S1*	·
Start Date: Required Date: Reference:	7/07/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:				Stop	*N	S2*	¥
Approvals:	Process Plan	:_ MLJ	Date: 14-67-67	Tooling:	Da	ıte:	_		Run	Start	*N	R1*	
	QC:			SPC (Y/N):	Da	ite:				Stop	*N	R2*	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revis	ion Nbr										Stamp	
D3414	Rev C												
100	_			0.00								<i>[</i>	DAS 23
Waterjet FLOW CNC Waterje	et	Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if r	<u>C</u>	0.00				<u> </u>		De		10/16	9-89
110 *110* QC Quality Control	(QC2- Inspect parts off m Memo	achine FAI/FAIB	0.00 0.00				8			De l	4/10/11	DAS () 23

Quality Control

DQA:		. Date:		WORK ORDER NON-CONFORMANCE / UPDATE							"DART		
QA Closed:		Date:			WORK ORDER NON-	-00	JNFOI	KIVIAINCE / OF		Wo	ork Order up	date only	AEROSPACE
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	Centre N	ot Conce	ntric	<u> </u>	BOM/Route		Grain				Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorre	<u> </u>	Temperature/Cure
	Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	$\overline{}$	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		-1	tions Incomplete/U	Inclear		Part Moved	L	Wrong Stock Pulled
	Crushing				Countersink	<u> </u>	Misali	gned/off center			Positioned V		
	Heat Tre	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Other
	Inspection	n Strip in	Tube		Drawing		Misrea	d					
	Marks/C	hatter			Drill Holes		Off-set						
	Turning 9	Sequence	:		Finish		Out of	Calibration					
	Wave/Tv	vist in Tu	he		Fit/Function		Out of	Seauence					

Work Ord Monday, July 0					*12	1953*							Page 2
Item ID: Revision ID: Item Name:	D3414-041				Accept	*N900	0040	110	N *	Setup	Start Stop	*N.	S1* S2*
Start Date: Required Date Reference:	7/07/14 : 7/07/14	Start Qty: 8.00 Req'd Qty: 8.00		*8* *8*		Cust Item :	ID:						
Approvals:	0.0	an:	_		Tooling: SPC (Y/N):		ate:			Run	Start Stop	*NF	
Sequence ID/ Work Center II	D .	Operation Description QC8- Inspect parts - second	nd check		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject	Insp. Stamp DAS
1 20 QC Quality Control		Memo			0.00	·			(g)) 	774V-14-1-1-1-1		38 9-89 14-16-14
130 *120* Brake NC		Мето			0.00	÷		DAS 30 9-89	8			-	14/06/14
Brake NC		1-Deburr 2-Form using	DT8254 as	per Dwg D34	.14								
140 *1 1 1 1 1 1 1 1 1 1 		Memo			0.00				8		/4	(-11- <u>1</u> 6	MAL
Large Fab		1- Weld using A/R S.S. we	g location Jig lding rod Ba	g DT9625 as t itch: M /23	per Dwg D3414								

DQA:		_ Date:			MORK ORDER MON			DAAANCE / LIDDATE				"DART
QA Closed:		Date:			WORK ORDER NON-	-((JNFOI	RIVIANCE / UPDATE	W	ork Order up	date only	AEROSPACE
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	Cracks				Broken/Damage/Defect	_	Hardwa		\vdash	Part Incorred	<u> </u>	Temperature/Cure
	Crimp/K	ink/Ripple	e/Wave		Burrs		4 '	ion Incomplete/Unqualified	 	Part Lost/Mi	issing	Weld
	Cuffs				Contamination		4	tions Incomplete/Unclear	\perp	Part Moved	L_	Wrong Stock Pulled
	Crushin	3			Countersink		-1	gned/off center	L	Positioned V	_	ا ا
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	Inspecti	on Strip ir	n Tube		Drawing		Misrea	d				
	Marks/0	Chatter			Drill Holes		Off-set					
•	Turning	Sequence	9		Finish		Out of	Calibration				
	Wave/T	wist in Tu	be		Fit/Function		Out of	Sequence				

Work Ord Monday, July 0				*12	1953*				Page 3
Item ID: Revision ID: Item Name: Start Date:	D3414-041 Lug 7/07/14	Start Qty: 8.00	*8*	Accept	*N9000)* Setu	p Start Stop	*NS1* *NS2*
Required Date: Reference:	: 7/07/14	Req'd Qty: 8.00	*8*		Customer:	J :			
Approvals:		lan:	Date:	Tooling: SPC (Y/N):	Dat		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II	D	Operation Description QC9- Inspect visual per	QSI004- Fusion Welds	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Ro		Reject Insp. Number Stamp
150 QC QC Ouality Control		Мето		0.00		8	CpCr	4.15	0.8
160	•	QC5- Inspect part comple	eteness to step on W/O	0.00		8	1		
1 AO QC Quality Control		Memo		0.00		\circ	P/	14.	12-8
170		White Gloss(Ref:4,3.5.1)	ner OSI005 4 3-Alum	0.00					
170 Powdercoat		M 12-18-8.	per Q51003 4.3-Alum	0.00			8 ø	14-	12-15. 38

0.00

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:
FINISH TIME:

DQA:			Date:							· -			"DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA		ork Order up	date only	AEROSPACE
a, r ciosca.			- Dute.			DISPOSITION					PARTMENT/	<u> </u>	
Work Orde	er:	o				DISPOSITION				AGAINST DE	PARTIVICIVI)	-FROCESS	
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Part N	۰۰۰ ا					Scrap			~ 	mall Fab	4	d. Eng. Coor.	Quality
			-			Use-as-is		Thern	Ŭ 	Finishing	Rec/Stor	e/Packaging	Other
NCR N	1o. <u> </u>					Suspected Unapproved			Large Fab Co	mposite	j	Supplier	_
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l a mali						General	FA	ULI CA	IEGORY				
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	_				-	Countersink			ned/off center		Positioned V	ــــ Vrong	
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				Tube		Drawing		Misrea			-	_	
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	Marks/Chatter Turning Sequence			Finish		4	Calibration						
	Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube				Fit/Function		Out of	Sequence					

Work Ord				*12	1953*							Page 4
Item ID: Revision ID: Item Name:	D3414-()41		Accept	*N900) <u>04</u> 0	10	N *	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	7/07/14 :: 7/07/14	Start Qty: 8.00 Req'd Qty: 8.00	*8:		Cust Item Customer:						"IN	·7/"
Approvals:		Plan:	Date:	Tooling:	D	ate:			Run	Start	~!\	R1*
	QC:_		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I 180 *180*	D	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept	t Rej Qty		Reject Number	Insp. Stamp 35 9-89
QC -Quality Control		Мето		0.00				(x)) _		DE	C 15 2014
190 *100* Packaging Packaging		Identify as per dwg & Stoo Memo	ck Location: <u>S</u>	0.00 0.00				DAS 		4		1 6 2014
200 *200* QC		QC21- Final Inspection - V	Work Order Release	0.00						14,	ואיבוא	7 4
Quality Control									HU	1-12	1121) 16	

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QA Closed:		Date:			WORK ORDER NON-	-((JNFOI	RIVIAINCE / UP	DATE	Wo	ork Order up	date only	AEROSPACE
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Part N	0.				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing		Rec/Stor	re/Packaging	Other
NCR N	0	····			Suspected Unapproved			Large Fab	Composite			Supplier	
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Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	QC Inspector
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}	Bending			-	Bend	ļ	1	Program			4	<u> </u>	Set-up
-	Centre No	ot Conce	ntric	<u> </u>	BOM/Route	-	Grain			⊩	Over/Under Part Incorre	<u> </u>	Temperature/Cure
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Picklist Print

Monday, July 07, 2014 9:50:32 AM

Work Order ID: 121953

121953

Parent Item:

D3414-041

D3414-041

Parent Item Name: Lug

Start Date: 7/07/14

Required Date: 7/07/14

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M304S12GA		Purchased	No		· , · · · · · · · · · · · · · · · · · ·	100	sf	109.6300	0.155	2	DAS	
M304S12	PGA					٠			**		23 9-89	DC 14/18/16
				Location		Loc (<u>Oty</u>	Loc Code				' /
				MAT019		109	9.63			_	_	
					113062	70	6.13				_	
					113077		19				-	
					m126389	1	14.5		_	1.718	-	
D3414-3		=Manufactured	No_			140	Each	32 0000=				many and a contract and an area
D3414-3	•								**	0		

Lug

B121776 x 5

Location Loc Qty Loc Code WA001 32 .114975 X 3 32

14-11-26 MAL

DQA:		_ Date:	•		MODIL ODDED NON		NEO	DAAANCE / LIDDATE				"DART
QA Closed:		Date:			WORK ORDER NON-	-((JNFOI	RIVIANCE / UPDATE	W	ork Order up	date only	AEROSPACE
					DISPOSITION			AGAIN	NST DE	PARTMENT	PROCESS	
Work Orde	er:			-	Rework			Skid-tube Crosstu	امما	1	Water Jet	Engineering
Part N	lo			_	Scrap Use-as-is			Machining Small I	ab	4	d. Eng. Coor.	Quality Other
NCR N	lo				Suspected Unapproved		mem	Large Fab Compos		, necystor	Supplier	
Root				Desci	ription of work order update	j	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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Landii	ng Gear			*	General					_	_	_
	Bending				Bend	Г	Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
	Centre I	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	i .	Temperature/Cure
	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing	3			Countersink		Misalig	ned/off center		Positioned V	Vrong	_
	Heat Tre	eat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspecti	on Strip in	Tube		Drawing		Misrea	t d				
	Marks/0	Chatter			Drill Holes		Off-set					
	Turning	Sequence	:		Finish	Г	Out of	Calibration			-	
	Wave/T	wist in Tu	be		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order: 121953	
Description: Lug Bracket	Part Number: D3414-1	
Inspection Dwg: D3414 Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing	Tolerance	Actual	Acc	ept	Reject	Method of	Comments
Dimension		Dimension				Inspection	
Ø0.313	+0.006/-0.001	\$13	-	•		V=5tm-01	
1.19	+/-0.030	1.19	-				
1.00	+/-0.030	1.00	1	•			
3.38	+/-0.030	3.34	1				
5.350	+/-0.010	5.35	-				
6.23	+/-0.030	6.23					
2.500	+/-0.010	2500					
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Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue P/O D3414-041	KJ/DD	
В	09.05.27	Dimensions updated per Dwg Rev B	KJ 10	
С	09.10.16	Dwg Rev updated to Rev C	KJ X	N

DQA:	Date:									DART						
QA Closed:			Date:		WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								AEROSPACE			
						DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Orde	٠					Rework	ıİ		Skid-tube Crosstube		1	Water Jet		Engineering		
Part N	۱o. ₋		······			Scrap Use-as-is			Machining Small Fab		Prod. Eng. Coor. Rec/Store/Packaging			Quality Other		
NCR I	۱o. ₋					Suspected Unapproved			Large Fab Composite		,	Supplier				
Root					Desci	ription of work order update	ı	nitial	Action		Sign &			•		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	1	QC Inspector		
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,	Ш	Bending			<u> </u>	Bend	<u> </u>	4 .	Program	<u> </u>	Outside Dim	F		Pressure/Forced		
	<u></u>	Centre Not Concentric				BOM/Route		Grain		-	Over/Under	F		Set-up		
	$oxed{oxed}$	Cracks				Broken/Damage/Defect		Hardwa		_	Part Incorre	F		Temperature/Cure		
	-	Crimp/Kink/Ripple/Wave				Burrs	<u> </u>	4 '	ion Incomplete/Unqualified	\vdash	Part Lost/M	ssing		Weld		
		Cuffs			_	Contamination	<u></u>	4	tions Incomplete/Unclear	<u> </u>	Part Moved	Ĺ		Wrong Stock Pulled		
	Crushing				<u> </u>	Countersink	<u></u>	•	gned/off center	<u> </u>	Positioned V	r		1		
	Heat Treat				Cut Too Short	L	Mislab			Power Loss/	Surge [Other			
		Inspectio		Tube		Drawing		Misrea								
		Marks/Cl	natter			Drill Holes	L	Off-set								
		Turning S	equence	!	<u> </u>	Finish		4	Calibration		-					
		Wave/Tw	ist in Tul	be		Fit/Function		Out of	Sequence							

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TEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	х	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 121953 MJ

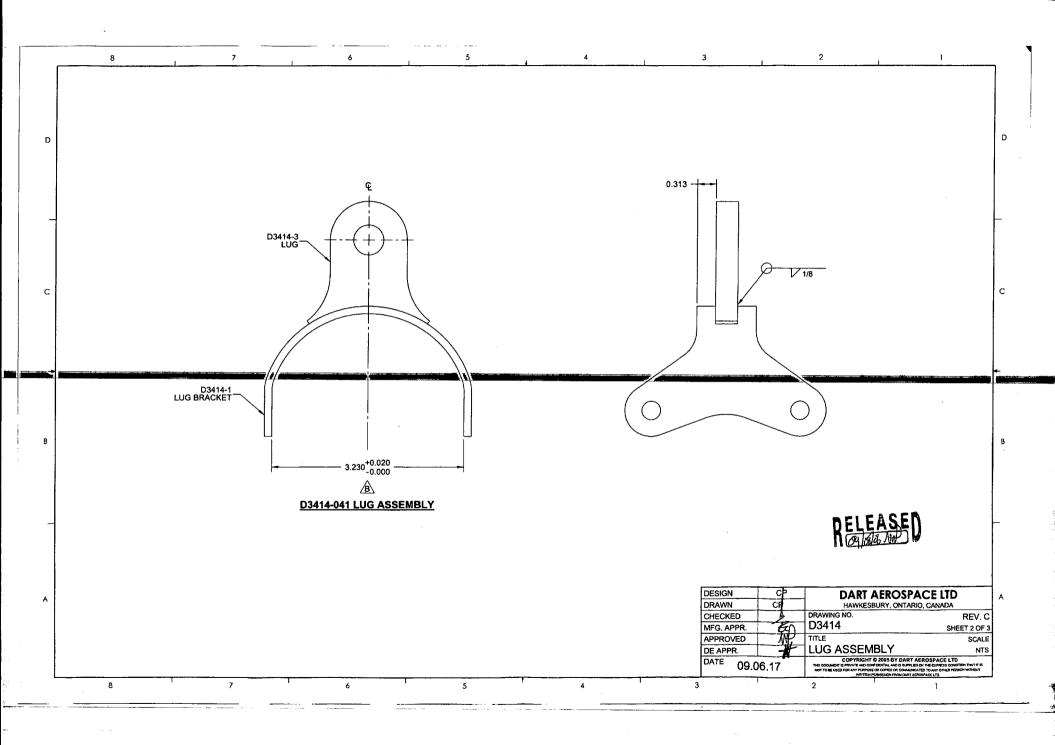
SHOP COPY

С		SHARP EDGE: 030 (ZN A7-3)	СР	09.06.17									
8	STANDA FLAT PA PREVEN REMOV OF MAN	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. FLAT PATTERN FOR 1: INGREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PARISB), FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. 87-3 ADDED TOLERANGE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.											
A	NEW IS:	SUE	CP 05.03.16										
REV.			BY	DATE									
DESIG	N	ďР	DART AEROSPACE LTD										
DRAW	N	CP	HAWKESBURY, ONTAR	O, CANADA									
CHECK	ED		DRAWING NO.		REV. C								
MFG. A	PPR.	.Psn	D3414	SHEET 1 OF									
APPRO	VED	WP	TITLE		SCALE								
DE API	PR.	→#	LUG ASSEMBLY	ASSEMBLY NTS									
DATE	09.0	6.17	COPYRIGHT © 2005 BY DART ACROSPACE LTD HIS DOCUMENT OF PRIVATE MIC COMPRESSION OF BE STATED FOR THE CONTROL THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPED OF COMMANCATED TO MY CHEEF PERSON WITHOUT WINDS AND THE COMPRESSION OF COMPRESSION OF THE CONTROL O										

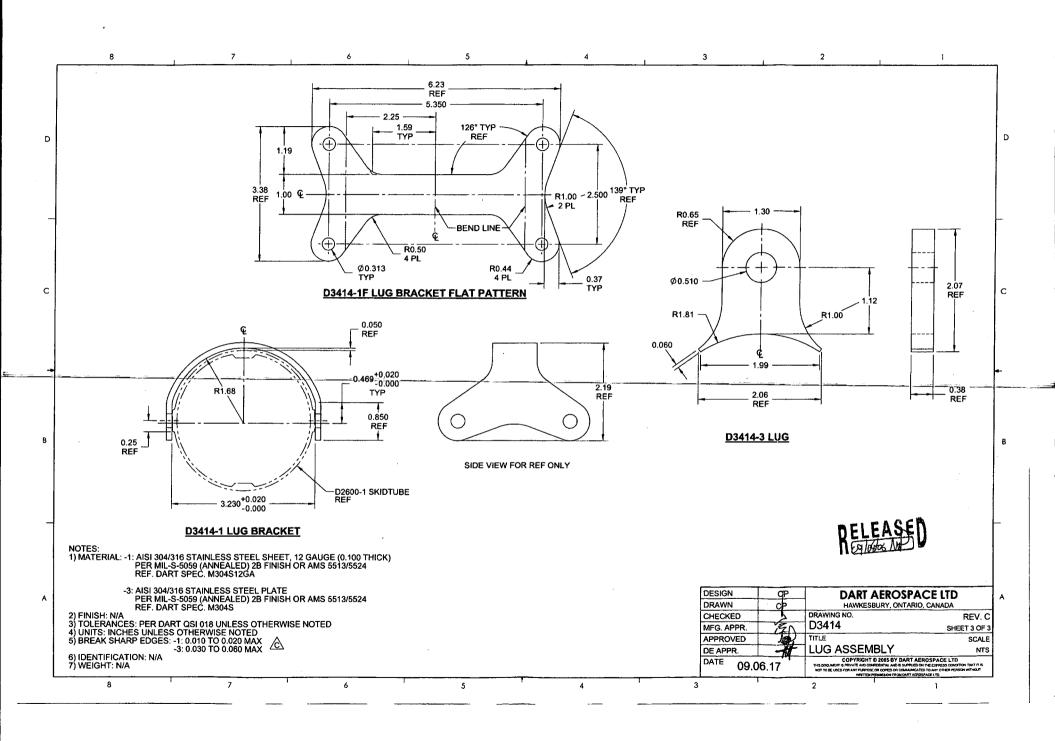
D3414-041 LUG ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: POUDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.52 lbs

DQA:		Date	:									TAAPT		
					WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:		Date	:						W	ork Order up	date only			
Work Orde	ar.				DISPOSITION			AGAINST						
Work Orac	-1 •				Rework	ı		Skid-tube Crosstube		1	Water Jet	Engineering		
Part N	lo.				Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality		
					Use-as-is			noforming Finishing	-	4	re/Packaging	Other		
NCR N	lo				Suspected Unapproved			Large Fab Composite	Ē]	Supplier			
Root		-		Desci	ription of work order update	i	nitial	Action		Sign &		· · · · · · · · · · · · · · · · · · ·		
Cause	Dat	e Step	Qty		or non-conformance		ief Eng	Description		Date	Verification	QC Inspector		
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ļ	Centre Not Concentric				BOM/Route		Grain		\perp	Over/Under		Set-up		
ļ	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		\vdash	Part Incorre	⊢	Temperature/Cure		
	Crimp/Kink/Ripple/Wave				Burrs	<u></u>	4	ion Incomplete/Unqualified	_	Part Lost/Mi	issing	Weld		
	Cuffs				Contamination	<u></u>	4	tions Incomplete/Unclear	_	Part Moved	L	Wrong Stock Pulled		
	Crushing				Countersink	\vdash	-1	gned/off center	-	Positioned V		٦٠٠٠		
	Heat Treat				Cut Too Short		Mislab			Power Loss/	Surge	Other		
		ction Strip i	n Tube		Drawing		Misrea			 				
l	_	s/Chatter			Drill Holes	<u> </u>	Off-set	,						
		ng Sequenc		igspace	Finish		4	Calibration		<u> </u>				
	Wave	/Twist in Tu	ıbe		Fit/Function		Out of	Sequence						



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	Cracks				Broken/Damage/Defect		Hardw		\vdash	Part Lost/M	-	Weld		
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	Cuffs			-	Contamination Countersink	\vdash	4	gned/off center	-	Positioned V	L Wrong			
	Crushing Heat Treat				Cut Too Short	\vdash	Mislab		\vdash	Power Loss/		Other		
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